Work Order <i>July-03-13 12:25:</i>		859 		*10:				Page 1			
Revision ID:	2367			Accept	*N900	<u>040</u>	100)* s	etup Start Stop	ı VI .	S1*
		Start Qty: 12.00 Req'd Qty: 12.00		*12* *12*		Cust Item ID: Customer:			эц	*N;	S2*
• •	Process Plan	ı: W	Date:	Tooling: SPC (Y/N):		ate:		R	tun Start Stop	1/3	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D2367	Rev A	A									
*1 \\ \ATTILDA \\ *ATTILDA \\ Hardinge Hardinge CNC Lathe S		Hardinge CNC LATHE Memo Machine as		0.00 0.00 wg D2367 Deburr	13-7-1	D		17	_Ø_		
110 *110* QC Quality Control	·	QC2- Inspect parts off i	machine FAI/FAIB	0.00	13-7-1	0		17	þ		
120 *120* QC Quality Control		QC8- Inspect parts - see	cond check	0.00 \bigcirc	\$\ \$\ 13/04/1	.5		15	\$		

DQA:		_ Date:			_							
					WORK ORDER NON	-CO	ONFO	RMANCE / UF	PDATE			
QA Closed:	· - · · · · · · · · · · · · · · · · · ·	Date:						_	\	Vork Order u	pdate only	1
Work Order	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
				_	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	_	re/Packaging	Other
NCR N	NCR No.				Suspected Unapproved]	Large Fab Composite				Supplier	
Root	- 			Desc	ription of work order update		L Initial	Acti	ion	Sign &	1	
Cause	Date	Step	Qty	Desc	or non-conformance	1	nief Eng			Date	Verification	QC Inspector
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-	Bending			<u> </u>	Bend	<u> </u>	4 '	Program		Outside Dim	ensions	Pressure/Forced
-		lot Concer	ntric	<u> </u>	BOM/Route		Grain			Over/Under	 	Set-up
-	Cracks				Broken/Damage/Defect		Hardwa			Part Incorre		Temperature/Cure
-	Crimp/Kink/Ripple/Wave			-	Burrs	<u> </u>	1	ion Incomplete/Un	·	Part Lost/M	` <u></u>	Weld
-	Cuffs			Contamination	<u> </u>	1	tions Incomplete/U	Inclear	Part Moved	L	Wrong Stock Pulled	
}-	Crushing				Countersink	L	1 ~	gned/off center	-	Positioned \		- -
}-	Heat Treat			_	Cut Too Short	<u></u>	Mislabe		L	Power Loss/	'Surge	Other
-		on Strip in	Tube	<u> </u>	Drawing	<u> </u>	Misread					
-	Marks/C			\vdash	Drill Holes	<u>_</u>	Off-set					
-	 -	Sequence		<u> </u>	Finish	L	4	Calibration				
1	Wave/Twist in Tube				Fit/Function	1	I Out of 9	Somuence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID 103859 *103859* Page 2 July-03-13 12:25:26 PM *N900040100* Accept Item ID: D2367 Setup Start **Revision ID:** Handle Knob Item Name: *12* 7/03/13 **Start Qty: 12.00 Start Date: Cust Item ID:** Req'd Qty: 12.00 Required Date: 7/19/13 **Customer:** Reference: Run Tooling: Process Plan: Date: Date: Approvals: Stop Date:_____ SPC (Y/N): Date: Reject Set Up/ Tool ID Tool # Plan Reject Sequence ID/ Accept Insp. Operation Code Qty **Qty** Number Stamp Description **Work Center ID Run Hours** Identify as per dwg & Stock Location 0.00 130 *130* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140

0.00

pl 13-07-12

Memo

140

Quality Control

QC

DQA:	!		ate: _		_							™ ∆∧DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			ate:			_			V	Vork Order up	odate only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
		†	•		Use-as-is			noforming	Finishing	 	re/Packaging	Other
NCR N	No				Suspected Unapproved	Large Fab Composite			Composite		Supplier	
Root		.		l l	cription of work order update		initial	Acti		Sign &		
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	├ ─┤	•	oncent	ric	BOM/Route		Grain		-	Over/Under	ļ	Set-up
	\vdash	Centre Not Concentric Cracks			Broken/Damage/Defect	<u> </u>	Hardwa	are	-	Part Incorre	-	Temperature/Cure
	Crimp/Kink/Ripple/Wave			Wave	Burrs	Г	1	ion Incomplete/Un	qualified	Part Lost/Mi	}	Weld
	Cuff	• •			Contamination		1 '	ions Incomplete/U	· -	Part Moved	ĭ þ	Wrong Stock Pulled
	Crushing				Countersink	-	4	ned/off center	<u> </u>	Positioned V	∟ Vrong	
	Heat Treat				Cut Too Short		Mislabe			Power Loss/		Other
	Inspection Strip in Tube			ube	Drawing		Misread	d	_	·		
	Mai	rks/Chatte	er		Drill Holes		Off-set					
	Turi	ning Sequ	ence		Finish		Out of 0	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of	Sequence		-		

Picklist Print

July-03-13 12:25:25 PM

Work Order ID:

103859

Parent Item:

D2367

Parent Item Name:

Handle Knob

Start Date: 7/03/13

Required Date: 7/19/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP, A02.10.29New issueKJ

Gomponent Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL'RINR1.2500 DELRIN ROUND BAR 1.	25"	Purchased	No			100	f	2.4000	0.045	0.5684211	12	. / 3	-7-10

Loc Qty Loc Code Location MAT018 2.4 125251 2.4

DQA:			Date:		·										DART
QA Closed:			Date:			WORK ORDER NON-	-८(JNFO	KIVIANCE / U		Wo	ork Order up	odate only	\neg	AEROSPACE
						DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
Work Orde	er:					0			G1:14.4 [T]	[_	_		\neg	
Part N	do					Rework Scrap			Skid-tube Crosstube			Water Jet			Engineering
raiti	•••					Use-as-is			Machining	Small Fab Finishing	\dashv		d. Eng. Coor.		Quality Other
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	-						•		20180 100	Composite			adphie:[لــ	
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Cause		Date Step Qty			or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	,	QC Inspector	
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Process	\dashv					•									
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Unapproved	L L			<u> </u>				IIIT CAT	FECORY						
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[nding				Bend	_] Folio/s	rogram	ſ	\neg	Outside Dim	ansions [\neg	Pressure/Forced
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	Crimp/Kink/Ripple/Wave			/Wave		Burrs	-	1	ion Incomplete/Ur	ngualified		Part Lost/Mi	-	_	Weld
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	Heat Treat					Cut Too Short		Mislabe		ŀ	\neg	Power Loss/S	· .	٦,	Other
	Inspection Strip in Tube					Drawing		Misread		L			, o-		· · - ·
	М	arks/Ch	atter			Drill Holes		Off-set			-				
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	Wave/Twist in Tube					Fit/Function		Out of S	Sequence		•				

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DART AEROSPACE LTD	Work Order:	103859
Description: Handle Knob	Part Number:	D2367
Inspection Dwg: D2367 Rev: A		Page 1 of 1

	x	First Artic	:le	_ Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.250	+/-0.010	1.253			51-9	Vers	
Ø0.193	+0.005/-0.000	-/53					
0.440	+/-0.010	.444					
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easured by:		Audited by:	OAS 44 9-89		Prototype Ap	oproval:	N/A
Date: /-	1-4-10	Date:	13/0	1/12/2		Date:	N/A
ev Date	Change				Re	vised by	Approve

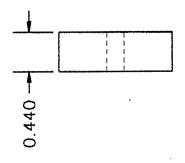
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DQA:			Date:			- WORK ORDER WON CONTOURNET (
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Vork Order u	odate only	AEROSPACE		
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						Rework			Skid-tube	Crosstube		Water Jet	Engineering		
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Root					Desc	ription of work order update		Initial	Act	tion	Sign &				
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	Cracks					Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure		
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	ssing	Weld		
	Cuffs					Contamination		Instruct	ions Incomplete/l	Jnclear	Part Moved		Wrong Stock Pulled		
		rushing				Countersink		Misalig	ned/off center	Γ	Positioned V		_		
	Heat Treat				Cut Too Short		Mislabe	eled	ſ	Power Loss/	Surge	Other			
	Inspection Strip in Tube				Drawing		Misread	t	_						
	$ \prod V $	/larks/Ch	atter			Drill Holes		Off-set							
*	∐Т	urning S	equence			Finish		Out of 0	Calibration						
	Wave/Twist in Tube					Fit/Function	Г	Out of	Seguence						

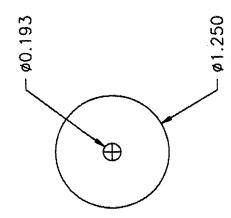


DESIGN B WILLIAMS	ORAWN BY	DART AEROS VICTORIA INTERNATIONAL	· · · • • • • • • • • • • • • • • • • •
CHECKED	APPROVED	DRAWING NO.	REV. A
Pow	IW	D2367	SHEET 1 OF 1
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10378



BREAK ALL EDGES .015 MAX MATERIAL: BLACK DELRIN

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